

Date: Tuesday, 5/23/2006 8:13:01 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CROSSBOLT SPACER	
Job Number	: 27167				
Estimate Number	: 10993				
P.O. Number	: N/A		Part Number	: D2579	
This Issue	: 5/23/2006	S.O. No. : N/A	Drawing Number	: D2579 REV D	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: D	
Previous Run	: 25977		Material	: N/A	
Written By			Due Date	: 6/15/2006	
Checked & Approved By			Qty:	505	
Comment	: Est E 08.06.17 Now turned on Cobra NG		Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W	
		Comment: Qty.: 0.3762 f(s)/Unit Total : 188.1075 f(s) 6061-T6 Tube .500 x.058W Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4) 0.500 Dia x 0.058 Wall Batch _____	M100423 16 M101118 En / MS 06/06/08 SOS
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA245	En / MS 06/06/08 SOS
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	En / MS 06/06/08 SOS
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	SA 06.06.08 SOS
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	SA 06.06.08 505

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
							16		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/06/09

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:13:01 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 27167

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

505

100606/09

Job Completion



in 06-06-09

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27167
Description: Cross Bolt Spacer	Part Number:	D2579
Inspection Dwg: D2579	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

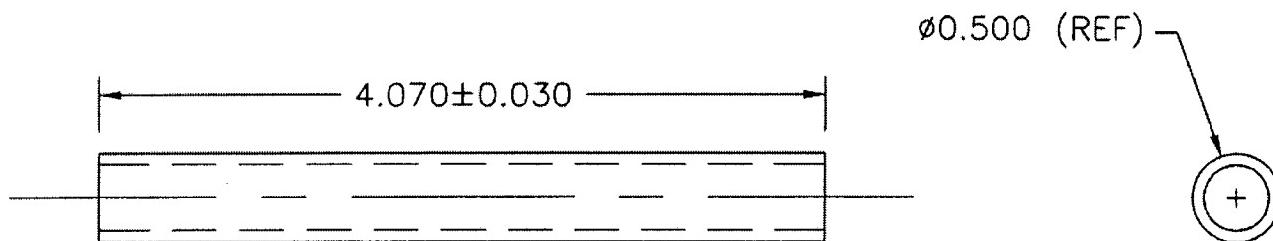
Measured by:	E.P.	Audited by:	J.L.	Prototype Approval:	N/A
Date:	06/06/07	Date:	06/06/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	IT

DART

DESIGN <i>[Signature]</i>	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2579	REV. D SHEET 1 OF 1
DATE 99.05.19		TITLE CROSS BOLT SPACER	SCALE 1:1

A	96.09.16	NEW ISSUE
B	96.12.05	0.065 WALL WAS 0.035 WALL
C	97.02.21	0.058 WALL WAS 0.065 WALL
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)

RELEASED
 99.05.20 DS


MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
 0.500 DIA x 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 27167

SHOP COPY
 RETURN TO
 ENGINEERING